

Work Order ID 77509

December-12-11 7:18:46 AM

77509

Page 1

Item ID: D2596

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 12/12/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/13/11 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

ET 11-12-12

ET 11-12-12

DP 11-12-12 (4)

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Page 2

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: **46**

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DP**11-12-12****(4)****11/12/13**
MF
11-12-12

Picklist Print

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Page 1

Work Order ID: 77509

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 12/12/11

Required Date: 12/13/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC. Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 Ext'n - I-Beam Web 4"		Manufactured	No			100	Each	64.0000	1	4			

Location

Loc Qty

Loc Code

LG

64

51957

2

66298

62

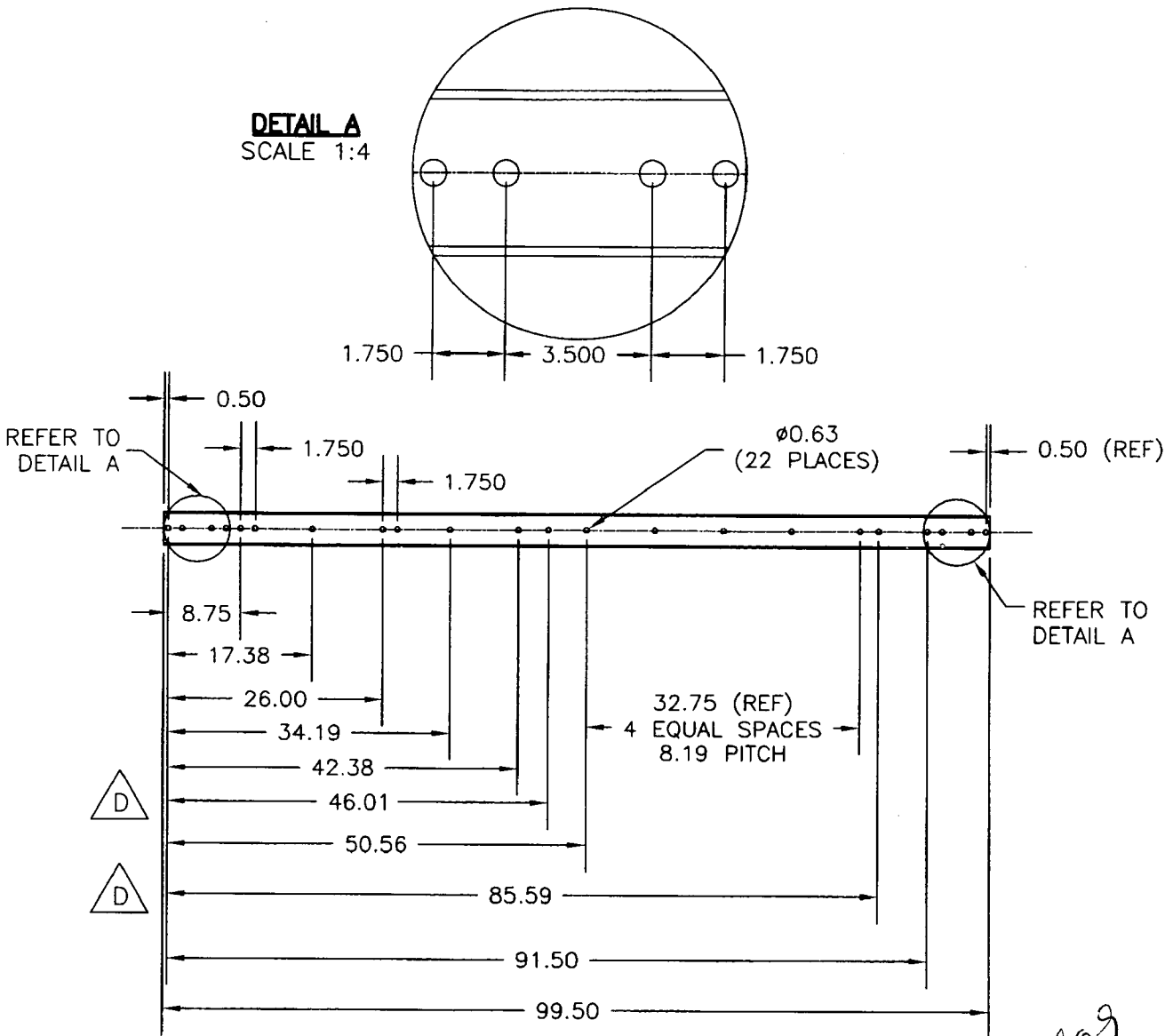
11-12-12

x 4

DART

RELEASED
07 DEC 1987

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 0		
<i>[Signature]</i>	<i>[Signature]</i>	D2596	SHEET 1 OF 1		
DATE	TITLE		SCALE		
07.04.17	205 WEB		1:20		
A	96.09.16	NEW ISSUE			
B	97.07.23	Ø0.63 HOLE WAS Ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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